

5/43

SPLIT

DART AEROSPACE LTD		Work Order:	24520 B
Description: Wearplate		Part Number:	D3460-3
Dwg: D3460 Rev. A; D2577 Rev. E		Qty:	8
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	KL	05.10.20	8
2	PG	Issue P/O: 2008744 Email or Ship DXF file to vendor Laser Cut D2577-101 flat pattern as per Dwg D2577 Material release note required	W	05.09.20	8
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	CL	05/10/12	8
4	QC6	Inspect dimensions per template D2577-101F	SB	05/10/20	8
5	GB	Deburr if necessary	N/A		
6	GB	Form on brake as per Dwg D2577 using DT8155 and DT8179	SB	05/10/20	8
7	GB	Form end joggle as per Dwg D2577 using DT8157 Identify as D3460-3	SB	05/10/24	8
8	GB	Form Detail "A" joggle of Dwg D3460 using DT8157	SB	05/10/24	8
9	QC5	Inspect work to Step 8		05.11.08	8
10	WS	Weld hard surface using DT8308A & DT8308B as per Dwg D3460 <div>Qty    Part Number    Description    Batch A/R                      7560 Hardcoat Rod    M17953 A18452</div>	CPL	05.11.16	4
11	QC9	Inspect weld	W	05/11/23	4
12	FP	Powder Coat Grey Sandtex (Ref.4.3.5.6) per QSI 005.4.3	W	05.11.24	4
13	QC3	Inspect Powder Coat	CL	05/11/25	4
14	ST	Identify and Stock	W	05.11.25	4
15	AC	Cost / part: _____	SUR	05.11.28	4
16	DC	Close W/O Inspect Level 21	CD	05/11/28	4

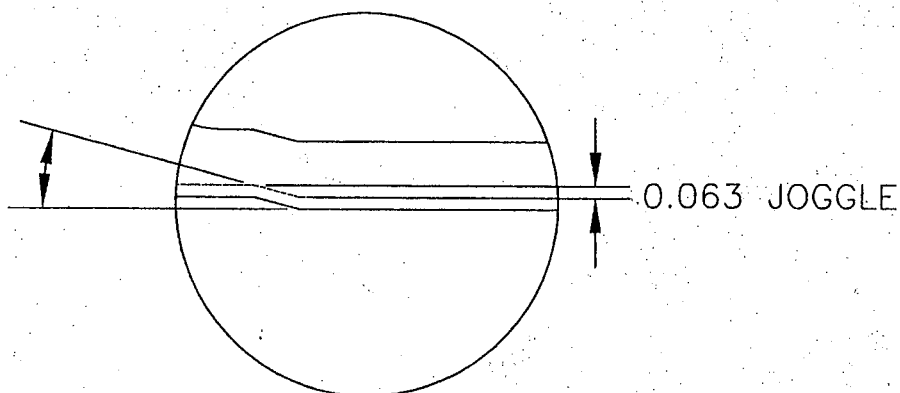
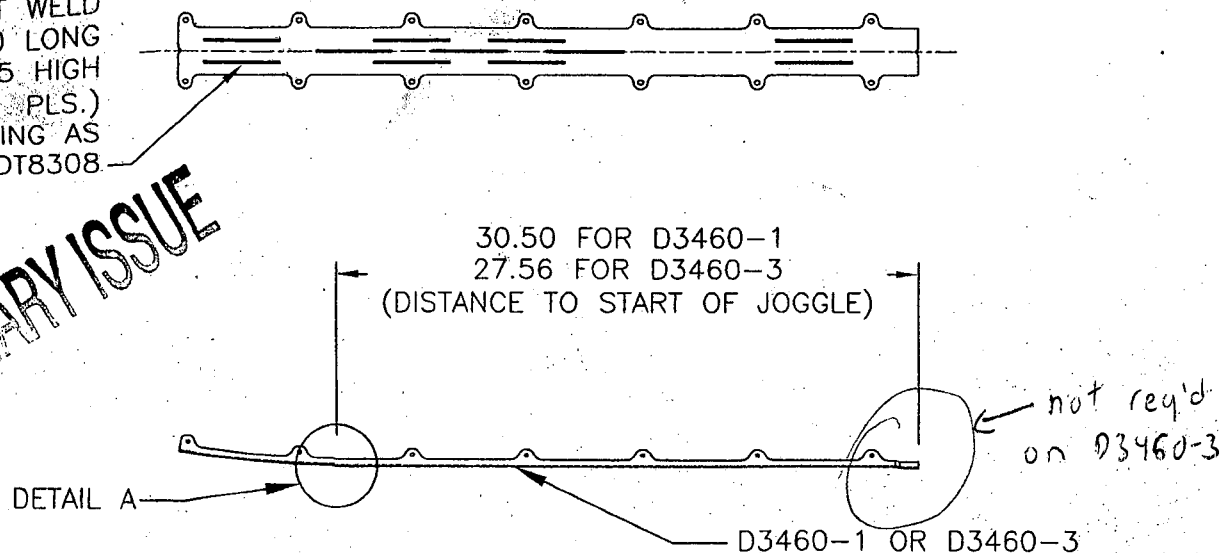
Rev	Date	Change	Revised By	Approved
A	05.10.20	New Issue	KJ/EC	B

PRELIMINARY ISSUE

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7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

**PRELIMINARY ISSUE**



DETAIL A  
(SCALE 1:1)

D3460-1/-3 WEARSHOE

- 1) MAKE D3460-1 FROM D2577-11 LONGITUDINAL BEND
- 2) MAKE D3460-3 FROM D2577-13 LONGITUDINAL BEND
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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COPY  
MENT  
WITHOUT  
TICE

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
		CHECKED	APPROVED
DATE 05.10.04	DRAWING NO. D3460		REV. A
	TITLE WEARSHOE		SHEET 1 OF 1
A	05.10.04	NEW ISSUE	
			SCALE 1:10